

Thursday, January 09, 2014 11:28:34 AM

111114

Page 1

N900040100

Setup Start *NS1*

Q

Stop *NS2*

Start Date: 1/8/2014 **Start Qty:** 1.00 ¹² ¹⁵ *1*

Cust Item ID:

Required Date: 1/24/2014 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: mf Date: 14-01-09

Tooling: _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr	
B67-43001-09	Rev C	

0.00

100

Large Fab

0.00

Large Fab

Memo

Large Fab

1- assemble parts on jig DT8814 and weld as per dwg PB67-43001

** Ensure no burn thru after welding in tube -235 and -229 only where bushing -265 ***

QC9- Inspect visual per QSI004- Fusion Welds

0.00

110

Memo

0.00

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

120

Memo

0.00

OC

Quality Control

Work Order ID 111114

Thursday, January 09, 2014 11:28:34 AM

111114

Page 2

Item ID: PB67-43001-09 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Aft Blade Fold Assembly Weldment
 Start Date: 1/8/2014 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 1/24/2014 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Powdercoat Powder Coating	Green Sandtex(Ref:4.3.5.8) per QSI005 4.3 Memo ***in detail D, mask in between -311 prior to paint*****mask 1.750" on the end of -243 prior to paint*****mask inside of D3440-9 prior to paint*** M 11/277 START TIME: 10:30 OVEN TEMPERATURE: 320 FINISH TIME: 11:00	0.00 0.00				2	φ	14-211	02 34 08
140 *140* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00		4/2/11		2			
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: W11.003 Memo	0.00 0.00				2	φ	14-02-14	

Work Order ID 111114***111114***

Page 3

Thursday, January 09, 2014 11:28:34 AM

Item ID: PB67-43001-09

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Blade Fold Assembly Weldment

Start Date: 1/8/2014 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 1/24/2014 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

14-02-1414-02-14

Picklist Print

Thursday, January 09, 2014 11:28:33 AM

Page 1

Work Order ID: 111114

Parent Item: PB67-43001-09

Parent Item Name: Aft Blade Fold Assembly Weldment

Start Date: 1/8/2014

Required Date: 1/24/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-06-25 new issue DD verified by:ec
dwg EC verified by:DD

IPP RevB 10.09.24 per revC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
PB67-43001-223 Square Cap	N/A	Manufactured	No			100	Each	21.0000	1	1		14-02-18	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				Mezz2		21							
				47504		21							
PB67-43001-225 Bushing	N/A	Manufactured	No			100	Each	35.0000	4	4		14-02-18	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				Mezz2		35							
				105193		18							
				99979		17							
PB67-43001-227 Bushing	N/A	Manufactured	No			100	Each	8.0000	2	2		14-02-18	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				Mezz2		8							
				107856		8							
PB67-43001-201 Square Tube		Manufactured	No			100	Each	8.0000	2	2		14-02-05	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				Mezz2		8							
				107861		8							
PB67-43001-203 Square Tube		Manufactured	No			100	Each	4.0000	1	1		14-02-05	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				Mezz2		4							
				99984		4							
PB67-43001-209 Square Tube		Manufactured	No			100	Each	0.0000	1	1		14-02-05	

B111/24 = (2)

Picklist Print

Thursday, January 09, 2014 11:28:33 AM

Page 2

Work Order ID: 111114

Parent Item: PB67-43001-09

Parent Item Name: Aft Blade Fold Assembly Weldment

Start Date: 1/8/2014

Required Date: 1/24/2014

Start Qty: 1.00

Required Qty: 1.00

PB67-43001-211 Manufactured No 100 Each 2.0000 6 6

Square Tube

Location Loc Qty Loc Code
Mezz2 3111125 = 12 2
107860 2

PB67-43001-213 Manufactured No 100 Each 11.0000 2 2

Flanged Hook

Location Loc Qty Loc Code
Mezz2 99981 11
99981 11

PB67-43001-229 Manufactured No 100 Each 3.0000 1 1

Outer Tube

Location Loc Qty Loc Code
Mezz2 99978 3
99978 3

PB67-43001-235 Manufactured No 100 Each 2.0000 1 1

Outer Tube

Location Loc Qty Loc Code
Mezz2 99977 2
99977 2

PB67-43001-239 Manufactured No 100 Each 3.0000 1 1

Square Tube

Location Loc Qty Loc Code
Mezz2 99976 3
99976 3

PB67-43001-243 Manufactured No 100 Each 2.0000 1 1

Tube Handle Extension

Location Loc Qty Loc Code
Mezz2 90925 2
90925 2

Thursday, January 09, 2014 11:28:33 AM

Shop Packet Print

Page 2

Picklist Print

Thursday, January 09, 2014 11:28:33 AM

Page 3

Work Order ID: 111114

Parent Item: PB67-43001-09

Start Date: 1/8/2014

Required Date: 1/24/2014

Parent Item Name: Aft Blade Fold Assembly Weldment

Start Qty: 1.00

Required Qty: 1.00

PB67-43001-277

Manufactured No

100

Each

12.0000

1

1

Contoured Male Eye

Location

Loc Qty

Loc Code

Mezz2

4

99964

4

WA003

8

110601

8

PB67-43001-311

Manufactured No

100

Each

4.0000

2

2

Restraint

Location

Loc Qty

Loc Code

Mezz

1

90935

1

Mezz2

3

99955

3

D3440-9

Manufactured No

100

Each

4.0000

1

1

Tube Detent Clip Base (Supersedes B67-43001-241)

Location

Loc Qty

Loc Code

Mezz2

4

108310

4

D3440-13

Manufactured No

100

Each

4.0000

1

1

Bracket (Supersedes B67-43001-273)

Location

Loc Qty

Loc Code

Mezz2

4

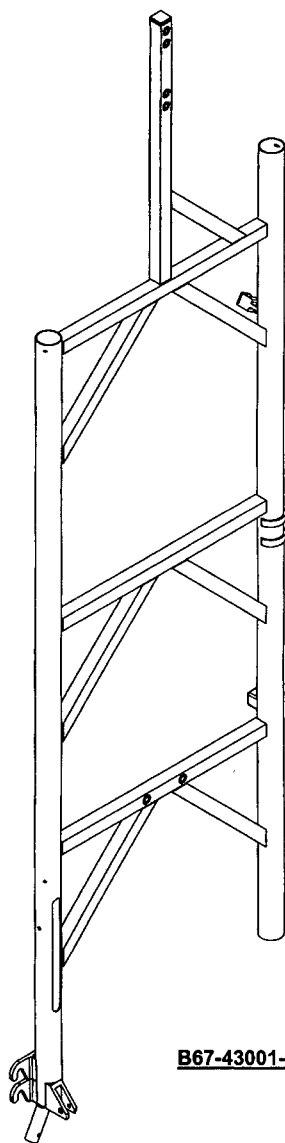
107855

4

Thursday, January 09, 2014 11:28:33 AM

Shop Packet Print

Page 3



B67-43001-09 AFT BLADE FOLD ASSY WELDMENT

ITEM	QTY -09	P/N	DESCRIPTION
1	X	B67-43001-09	AFT BLADE FOLD ASSEMBLY WELDMENT
2	2	B67-43001-201	SQUARE TUBE
3	1	B67-43001-203	SQUARE TUBE
4	1	B67-43001-209	SQUARE TUBE
5	6	B67-43001-211	SQUARE TUBE
6	2	B67-43001-213	FLANGED HOOK
7	1	B67-43001-223	SQUARE CAP
8	4	B67-43001-225	BUSHING
9	2	B67-43001-227	BUSHING
10	1	B67-43001-229	OUTER TUBE
11	1	B67-43001-233	OUTER TUBE END CAP
12	1	B67-43001-235	OUTER TUBE
13	1	B67-43001-239	SQUARE TUBE
14	1	B67-43001-243	TUBE HANDLE EXTENSION
15	1	B67-43001-277	CONTOURED MALE EYE
16	2	B67-43001-311	RESTRAINT
17	1	D3440-9	TUBE DETENT CLIP BASE
18	1	D3440-13	BRACKET

mk
14-01-09
#111114

RELEASED
2010-09-16
ND

C	REDRAWN PREMIER AVIATION DRAWING (AW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 6 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	10.05.03
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	JP	DRAWING NO.	REV. C	
CHECKED	JP	B67-43001-09	SHEET 1 OF 3	
MFG. APPR.	JP	TITLE	SCALE	
APPROVED	JP	AFT BLADE FOLD ASSY WELDMENT	NTS	
DE APPR.	N/A	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		
DATE	10.05.03			

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

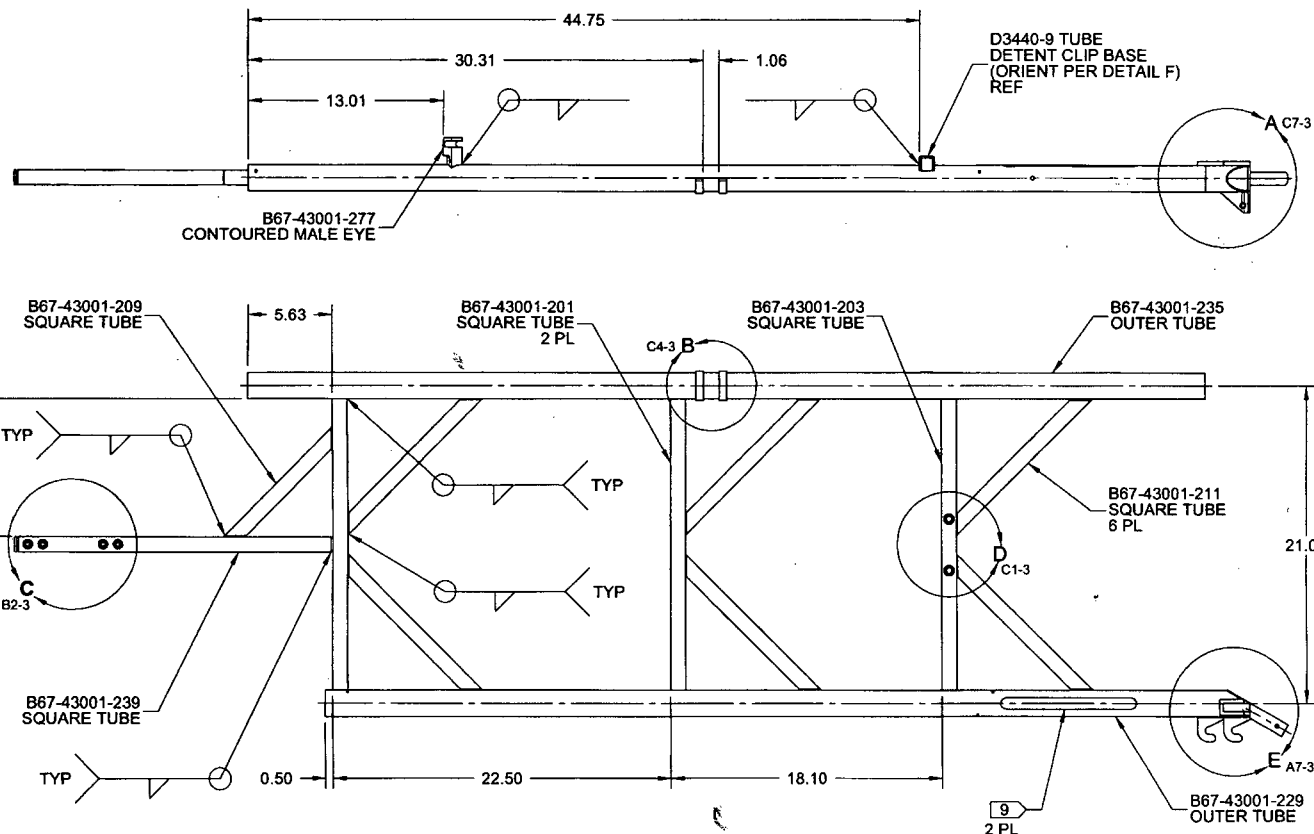
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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B67-43001-09 AFT BLADE FOLD ASSY WELDMENT

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: POWDER COAT "GREEN SANDEX" (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 7.74 lbs
- 8) WELDING: PER QSI 004
- 9) MASKING: ALL OPENINGS AND INDICATED AREAS PRIOR TO POWDER COATING

DESIGN	RW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		B67-43001-09	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.	N/A	AFT BLADE FOLD ASSY WELDMENT	NTS
DATE	10.05.03	COPYRIGHT © 1985 BY DART AEROSPACE LTD	
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RELEASED
2010-09-16

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Crosstube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
--	--	---	--

MATE WITH TOP SURFACE OF LOWER HOOK AND ALIGN WITH CENTERLINE OF OUTER TUBE

ALIGN WITH BOTTOM EDGE OF END CAP AND CENTERLINE OF OUTER TUBE

ALIGN WITH CENTERLINE OF OUTER TUBE AND FLUSH WITH ANGLED CUT

B67-43001-243 TUBE HANDLE EXTENSION REF

ALIGN WITH CENTERLINE OF OUTER TUBE AND TO BOTTOM SURFACE OF END CAP

D3440-13 BRACKET

DETAIL A D3-2
SCALE 4X

MASK ALL AROUND TUBE PRIOR TO POWDER COATING

B67-43001-311 RESTRAINT 2 PL

B67-43001-201 SQUARE TUBE REF

B67-43001-235 OUTER TUBE REF

DETAIL B C5-2
SCALE 4X

B67-43001-203 SQUARE TUBE REF

B67-43001-227 BUSHING 2 PL

B67-43001-211 SQUARE TUBE REF

9 2 PL

DETAIL D B4-2
SCALE 4X

B67-43001-229 OUTER TUBE REF

MASK INSIDE SURFACES OF BRACKET PRIOR TO POWDER COATING

B67-43001-243 TUBE HANDLE EXTENSION

B67-43001-213 FLANGED HOOK 2 PL

MASK INSIDE SURFACE OF HOOK PRIOR TO POWDER COATING

DETAIL E B3-2
SCALE 4X

B67-43001-223 SQUARE CAP 2 PL

9 4 PL

B67-43001-225 BUSHING 4 PL

B67-43001-239 SQUARE TUBE REF

4 PL

DETAIL C B8-2
SCALE 4X

MASK INSIDE SURFACE AND HOLE (NOT SHOWN) OF CONTOURED MALE EYE PRIOR TO POWDER COATING

D3440-9 TUBE DETENT CLIP BASE
MASK THREADED HOLE (NOT SHOWN) PRIOR TO POWDER COATING

DETAIL F C2-2
SCALE 4X

RELEASED
2010-09-16

DESIGN	RW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		B67-43001-09	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.	N/A	AFT BLADE FOLD ASSY WELDMENT	NTS
DATE	10.05.03	COPYRIGHT © 1985 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Material									
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Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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